

[NAME OF DOCUMENT] SPECIFICATION

[TITLE OF THE INVENTION]

CONDUCTIVE PASTE FOR A MULTI-LAYERED CERAMIC
ELECTRONIC COMPONENT AND A METHOD FOR
5 MANUFACTURING A MULTI-LAYERED UNIT FOR A
MULTI-LAYERED CERAMIC ELECTRONIC COMPONENT

[FIELD OF THE INVENTION]

[0001]

10 The present invention relates to a conductive paste for a
multi-layered ceramic electronic component and a method for
manufacturing a multi-layered unit for a multi-layered ceramic electronic
component, and particularly to a conductive paste for a multi-layered
ceramic electronic component which does not dissolve a binder contained
15 in a layer adjacent to an electrode layer of the multi-layered ceramic
electronic component and can reliably prevent short circuit failure from
occurring in a multi-layered ceramic electronic component and a method
for manufacturing a multi-layered unit for a multi-layered ceramic
electronic component which can reliably prevent short circuit failure from
20 occurring in a multi-layered ceramic electronic component.

[BACKGROUND OF THE INVENTION]

[0002]

25 Recently, the need to downsize various electronic devices makes it
necessary to downsize the electronic components incorporated in the
devices and improve the performance thereof. Also in multi-layered
ceramic electronic components, such as multi-layered ceramic capacitors,
it is strongly required to increase the number of layers and make the

laminated unit thinner.

[0003]

When a multi-layered ceramic electronic component as typified by a multi-layered ceramic capacitor is to be manufactured, ceramic powders,
5 a binder such as an acrylic system resin, a butyral resin or the like, a plasticizing agent such as a phthalate ester, glycol, adipate ester, phosphate ester or the like, and an organic solvent such as toluene, methyl ethyl ketone, acetone or the like are mixed and dispersed, thereby preparing a dielectric paste for a ceramic green sheet.

10 [0004]

The dielectric paste is then applied onto a support sheet made of polyethylene terephthalate (PET), polypropylene (PP) or the like using an extrusion coater, a gravure coater or the like to form a coating layer and the coating layer is heated to dryness, thereby fabricating a ceramic green
15 sheet.

[0005]

Further, a conductive powder of nickel or the like and a binder are dissolved into a solvent such as terpineol, thereby preparing a conductive paste and the thus prepared conductive paste is printed on the ceramic
20 green sheet in a predetermined pattern using a screen printing machine and dried, thereby forming an electrode layer.

[0006]

When the electrode layer has been formed, the ceramic green sheet on which the electrode layer is formed is peeled off from the support sheet
25 to form a multi-layered unit including the ceramic green sheet and the electrode layer. Then, a ceramic green chip is formed by laminating a desired number of the multi-layered units to form the laminated body, pressing the laminated body and dicing the laminated body.

[0007]

Finally, the binder is removed from the green chip, the green chip is baked and an external electrode is formed, thereby completing a multi-layered ceramic electronic component such as a multi-layered ceramic capacitor.

[0008]

At present, the need to downsize electronic components and improve the performance thereof makes it necessary to set the thickness of the ceramic green sheet determining the spacing between layers of a multi-layered ceramic capacitor to be equal to or smaller than 3 μm or 2 μm and to laminate three hundred or more multi-layered units each including a ceramic green sheet and an electrode layer.

[DISCLOSURE OF THE INVENTION]

[PROBLEMS TO BE SOLVED BY THE INVENTION]

[0009]

However, in the case where an electrode layer is formed by printing a conductive paste prepared using terpeneol, which is highly popular as a solvent for a conductive paste, on a ceramic green sheet formed using an acrylic system resin, which is the most popular binder for a ceramic green sheet, the binder contained in the ceramic green sheet is dissolved by terpeneol contained in the conductive paste and a ceramic green sheet is swollen or partially dissolved, whereby pinholes and cracks are generated in the ceramic green sheet to cause short circuit failure.

[0010]

One proposed solution for these problems is to employ a hydrocarbon system solvent such as kerosene, decane or the like as the solvent for the conductive paste. However, since a hydrocarbon system

solvent such as kerosene, decane or the like does not dissolve the binder component used for the conductive paste, it is impossible to completely replace the conventional solvent such as terpeneol with a hydrocarbon system solvent such as kerosene, decane or the like. Therefore, since the acrylic system resin contained in the ceramic green sheet as a binder is still soluble in the solvent contained in the conductive paste to some extent, it is difficult to prevent generation of pinholes and cracks in the ceramic green sheet in the case where the ceramic green sheet is very thin, and since the viscosity of a hydrocarbon system solvent such as kerosene, decane or the like is lower than that of terpeneol, it is difficult to control the viscosity of the conductive paste.

[0011]

Furthermore, Japanese Patent Application Laid Open No. 5-325633, Japanese Patent Application Laid Open No. 7-21833 and Japanese Patent Application Laid Open No. 7-21832 propose a conductive paste prepared using a hydrogenated terpeneol such as dihydroterpeneol or a terpene system solvent such as dihydroterpeneol acetate instead of terpeneol as a solvent. However, since the acrylic system resin contained in the ceramic green sheet as a binder is also soluble in a hydrogenated terpeneol such as dihydroterpeneol or a terpene system solvent such as dihydroterpeneol acetate to some extent, it is difficult to prevent generation of pinholes and cracks in a ceramic green sheet in the case where the ceramic green sheet is very thin.

[0012]

Further, Japanese Patent Application Laid Open No. 2002-270456 discloses a multi-layered ceramic electronic component fabricated by printing a conductive paste containing isobornyl acetate as a solvent, which hardly dissolves a butyral system resin, on a ceramic green sheet

containing a butyral system resin as a binder, thereby forming an electrode layer and discloses that it is preferable to employ ethyl cellulose as a binder of the conductive paste. However, since a conductive paste containing ethyl cellulose as a binder and isobornyl acetate as a solvent
5 has low viscosity and high fluidity, when the conductive paste is printed on a ceramic green sheet using a screen printing machine, the conductive paste leaks from a screen printing plate and the electrode layer cannot be printed in a desired manner. Further, the thus printed electrode layer tends to blot.

10 [0013]

It is therefore an object of the present invention to provide a conductive paste for a multi-layered ceramic electronic component which does not dissolve a binder contained in a layer adjacent to an electrode layer of the multi-layered ceramic electronic component, can reliably
15 prevent short circuit failure from occurring in a multi-layered ceramic electronic component and has excellent printability.

[0014]

It is another object of the present invention to provide a method for manufacturing a multi-layered unit for a multi-layered ceramic electronic
20 component which can reliably prevent short circuit failure from occurring in a multi-layered ceramic electronic component and form an electrode layer in a desired manner.

[MEANS FOR SOLVING THE PROBLEMS]

25 [0015]

The inventors of the present invention vigorously pursued a study for accomplishing the above objects and, as a result, made the discovery that in the case where a conductive paste was prepared using a binder

containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X were selected so that $X * MW_L + (1-X) * MW_H$ fell within a range of 145,000 to 215,000, and at least one kind of solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate, it was possible to prepare a conductive paste having a viscosity suitable for printing and dissolve a binder of the conductive paste in a binder in a desired manner and even when the conductive paste was printed on a ceramic green sheet containing an acrylic system resin as a binder, the binder contained in the ceramic green sheet was not dissolved in the solvent contained in the dielectric paste and it was therefore possible to reliably prevent generation of pinholes and cracks in the ceramic green sheet even in the case where the ceramic green sheet was very thin.

[0016]

The present invention is based on these findings and therefore, the objects of the present invention can be accomplished by a conductive paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least one kind of solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and

acetoxy-methoxyethoxy-cyclohexanol acetate.

[0017]

The objects of the present invention can be also accomplished by a method for manufacturing a multi-layered unit for a multi-layered ceramic electronic component comprising a step of printing a conductive
5 paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within
10 a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, l-menthyl acetate, l-citronellol, l-perillylalcohol and acetoxy-methoxyethoxy-cyclohexanol acetate on a ceramic green sheet
15 containing an acrylic system resin as a binder in a predetermined pattern, thereby forming an electrode layer.

[0018]

According to the present invention, it is possible to prepare a conductive paste having a viscosity suitable for printing and form an
20 electrode layer in a desired manner. Further, according to the present invention, even when the conductive paste is printed on a very thin ceramic green sheet containing an acrylic system resin as a binder, since the binder contained in the ceramic green sheet is not dissolved in the solvent contained in the dielectric paste, it is possible to reliably prevent
25 the ceramic green sheet from being swollen or partially dissolved and it is therefore possible to reliably prevent generation of pinholes and cracks in the ceramic green sheet even in the case where the ceramic green sheet is very thin.

[0019]

In the present invention, it is preferable for MW_L , MW_H and X to be selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 155,000 to 205,000.

5 [0020]

In the present invention, it is preferable for the weight-average molecular weight of an acrylic system resin contained in the ceramic green sheet as a binder to be equal to or larger than 250,000 and equal to or smaller than 500,000 and it is more preferable for the weight-average
10 molecular weight of an acrylic system resin to be equal to or larger than 450,000 and equal to or smaller than 500,000.

[0021]

In the present invention, it is preferable for the acid value of an acrylic system resin contained in the ceramic green sheet as a binder to be
15 equal to or larger than 5 mgKOH/g and equal to or smaller than 10 mgKOH/g and in the case where an acrylic system resin whose acid value is equal to or larger than 5 mgKOH/g and equal to or smaller than 10 mgKOH/g is employed as the binder of a ceramic green sheet, it is possible to prepare a dielectric paste for forming a ceramic green sheet so
20 as to have a desired viscosity.

[0022]

In a preferred aspect of the present invention, prior to forming the electrode layer or after forming and drying the electrode layer, a dielectric paste containing a binder containing ethyl cellulose having a weight
25 average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the

group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate is printed on a ceramic green sheet in a complementary pattern to that of the electrode layer, thereby forming a spacer layer.

[0023]

According to this preferred aspect of the present invention, since a spacer layer is formed on a ceramic green sheet in a complementary pattern to that of the electrode layer, it is possible to prevent a step from being formed between the surface of the electrode layer and the surface of the ceramic green sheet where no electrode layer is formed. Therefore, even in the case of laminating a number of multi-layered units each including a ceramic green sheet and an electrode layer and fabricating a multi-layered electronic component such as a multi-layered ceramic capacitor, it is possible to effectively prevent the thus fabricated multi-layered electronic component from being deformed and also effectively prevent delamination of layers from occurring.

[0024]

Further, since a mixed solvent of terpineol and kerosene, dihydroterpineol, terpineol or like, which is popular as a solvent for a dielectric paste for forming a spacer layer, dissolves an acrylic system resin contained in a ceramic green sheet as a binder, when a spacer layer is formed on a ceramic green sheet, the ceramic green sheet is swollen or partially dissolved, whereby voids are generated at the interface between the ceramic green sheet and the spacer layer or fissures or wrinkles are generated on the surface of the spacer layer. As a result, in the case where a multi-layered ceramic capacitor is fabricated by laminating a number of

multi-layered units to fabricate a laminated body and baking the laminated body, voids are generated in the multi-layered ceramic capacitor. Further, in the case where fissures or wrinkles are generated on the surface of the spacer layer, since the portions of the spacer layer where fissures or wrinkles are generated tend to drop off, when a number of multi-layered units are laminated to fabricate a laminated body, the portions of the spacer layer where fissures or wrinkles are generated mix into the laminated body as a foreign substance, thereby causing internal defects in the multi-layered ceramic capacitor and generating voids at portions where the spacer layer is missing. However, according to this preferred aspect of the present invention, since a dielectric paste for forming a spacer layer contains a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate and the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves an acrylic system resin contained in a ceramic green sheet as a binder, it is possible to reliably prevent the ceramic green sheet from being swollen or partially dissolved so as to generate voids at the interface between the ceramic green sheet and the spacer layer or

generate fissures or wrinkles on the surface of the spacer layer, and it is therefore possible to reliably prevent voids from being generated in a multi-layered ceramic electronic component such as a multi-layered ceramic capacitor.

5 [0025]

Moreover, since a dielectric paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate has a viscosity suitable for printing, a spacer layer can be formed on a ceramic green sheet in a desired manner by printing a dielectric paste on the ceramic green sheet in a complimentary pattern to that of an electrode layer.

[0026]

20 Further, in a study done by the inventors of the present invention, it was found that in the case of printing a conductive paste on a very thin ceramic green sheet to form an electrode layer, the solvent contained in the conductive paste for forming the electrode layer dissolved or swelled a binder component contained in the ceramic green sheet and, on the other hand, the conductive paste permeated into the ceramic green sheet, thereby causing short circuit failure and that, therefore, it was preferable to form the electrode layer on a support sheet separately from the ceramic green sheet and bond it onto the surface of the ceramic green sheet via an

adhesive layer after drying it. However, in the case where the electrode layer is formed on the support sheet separately from the ceramic green sheet in this manner, in order to make the support sheet easy to peel off from the electrode layer, it is preferable to form a release layer containing the same binder as that contained in the ceramic green sheet on the support sheet and print a conductive paste on the release layer, thereby forming an electrode layer. Even in the case of printing a conductive paste on the release layer containing the same binder as that contained in the ceramic green sheet to form an electrode layer, when the release layer contains an acrylic system resin as a binder and the conductive paste contains terpeneol as a solvent, the binder contained in the release layer is dissolved by the solvent contained in the conductive paste so that the release layer is swollen or partially dissolved, whereby voids are generated at the interface between the release layer and the electrode layer or fissures or wrinkles are generated on the surface of the electrode layer. As a result, in the case where a multi-layered ceramic capacitor is fabricated by laminating a number of multi-layered units to fabricate a laminated body and baking the laminated body, voids are generated in the multi-layered ceramic capacitor. Furthermore, in the case where fissures or wrinkles are generated on the surface of the electrode layer, since the portions of the electrode layer where fissures or wrinkles are generated tend drop off, when a number of multi-layered units are laminated to fabricate a laminated body, the portions of the electrode layer where fissures or wrinkles are generated mix into the laminated body as a foreign substance, thereby causing internal defects in the multi-layered ceramic capacitor and generating voids at portions where the electrode layer was missing.

[0027]

However, according to the present invention, the electrode layer is formed using the conductive paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate and the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves the acrylic system resin contained in the ceramic green sheet as a binder. Therefore, even in the case of forming a release layer containing the same binder as that contained in the ceramic green sheet and printing a conductive paste on the release layer to form an electrode layer it is possible to reliably prevent the release layer from being swollen or partially dissolved so as to generate voids at the interface between the release layer and the electrode layer or generate fissures or wrinkles on the surface of the electrode layer and it is therefore possible to effectively prevent defects from being generated in a multi-layered ceramic electronic component such as a multi-layered ceramic capacitor.

[TECHNICAL ADVANTAGES OF THE INVENTION]

[0028]

According to the present invention, it is possible to provide a conductive paste for a multi-layered ceramic electronic component which does not dissolve a binder contained in a layer adjacent to an electrode layer of the multi-layered ceramic electronic component, can reliably prevent short circuit failure from occurring in a multi-layered ceramic electronic component and has excellent printability.

[0029]

Further, according to the present invention, it is possible to provide a method for manufacturing a multi-layered ceramic electronic component which can reliably prevent short circuit failure from occurring in a multi-layered ceramic electronic component and form an electrode layer in a desired manner.

[DESCRIPTION OF THE PREFERRED EMBODIMENTS]

[0030]

In a preferred embodiment of the present invention, a dielectric paste for a ceramic green sheet which contains an acrylic system resin as a binder is first prepared and is applied onto a long support sheet using an extrusion coater or a wire bar coater, thereby forming a coating layer.

[0031]

A dielectric paste for forming a ceramic green sheet is normally prepared by kneading a dielectric material (ceramic powder) and an organic vehicle obtained by dissolving an acrylic system resin into an organic solvent.

[0032]

It is preferable for the weight-average molecular weight of the acrylic system resin to be equal to or larger than 250,000 and equal to or smaller than 500,000 and it is more preferable for the weight-average

molecular weight of the acrylic system resin to be equal to or larger than 450,000 and equal to or smaller than 500,000.

[0033]

Further, it is preferable for the acid value of the acrylic system
5 resin to be equal to or larger than 5 mgKOH/gram and equal to or smaller than 10 mgKOH/gram.

[0034]

An organic solvent used for preparing the organic vehicle is not particularly limited and an organic solvent such as terpineol, butyl
10 carbitol, acetone, toluene, ethyl acetate and the like can be used for preparing the organic vehicle.

[0035]

The dielectric material can be selected from among various compounds capable of forming a composite oxide or oxide, such as a
15 carbonate, nitrate, hydroxide, organic metallic compound and the like and mixtures thereof. The dielectric material is normally used in the form of a powder whose average particle diameter is about 0.1 μm to about 3.0 μm . The particle diameter of the dielectric raw material is preferably smaller than the thickness of the ceramic green sheet.

20 [0036]

The amounts of the respective constituents contained in the dielectric paste is not particularly limited and the dielectric paste may be prepared so as to contain 100 weight parts of a dielectric material, about 2.5 weight part to about 10 weight parts of an acrylic system resin and
25 about 50 weight parts to about 300 weight parts of a solvent, for example.

[0037]

As occasion demands, the dielectric paste may contain additives selected from among various dispersing agents, plasticizing agents,

antistatic auxiliary agent, releasing agent, wetting agent and the like. In the case of adding these additives to the dielectric paste, it is preferable to set the total content to be equal to or less than about 20 weight %.

[0038]

5 As a support sheet coated with the dielectric paste, a polyethylene terephthalate film is employed, for example, and the surface of the support sheet may be coated with a silicon resin, an alkyd resin or the like in order to improve the releasability thereof.

[0039]

10 The coating layer is then dried at a temperature of about 50 °C to about 100 °C for about 1 to about 20 minutes, whereby a ceramic green sheet is formed on the support sheet.

[0040]

15 In the present invention, the thickness of the ceramic green sheet after drying is preferably equal to or thinner than 3 μm and more preferably equal to or thinner than 1.5 μm.

[0041]

20 Next, a conductive paste for forming an electrode layer is printed on the ceramic green sheet formed on the long support sheet in a predetermined pattern using a screen printing machine, a gravure printing machine or the like.

[0042]

25 It is preferable to form the electrode layer so as to have a dry thickness of about 0.1 μm to about 5 μm and it is more preferable to form the electrode layer so as to have a dry thickness of about 0.1 μm to about 1.5 μm.

[0043]

The conductive paste usable for forming an electrode layer is

prepared by kneading a conductive material containing any of various conductive metals or alloys, any of various oxides which will form a conductive material containing any of various conductive metals or alloys after baking, an organic metal compound, resinate or the like, and an
5 organic vehicle prepared by dissolving a butyral system resin in an organic solvent.

[0044]

In this preferred embodiment of the present invention, the conductive paste contains a binder containing ethyl cellulose having a
10 weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl
15 ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate.

[0045]

Since the solvent selected from the group consisting of isobornyl
20 acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves the acrylic system resin contained in a ceramic green sheet as a binder, even in the
25 case of printing the conductive paste on a very thin ceramic green sheet, thereby forming an electrode layer, it is possible to effectively prevent the binder contained in the ceramic green sheet from being dissolved by the solvent contained in the conductive paste, whereby the ceramic green

sheet is swollen or partially dissolved. It is therefore possible to reliably prevent generation of pinholes and cracks in the ceramic green sheet even in the case where the ceramic green sheet is very thin.

[0046]

5 Further, since a conductive paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least
10 one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxymethoxyethoxycyclohexanol acetate has a viscosity suitable for printing, it is possible to print a
15 conductive paste on a ceramic green sheet using a screen printing machine, a gravure printing machine or the like to form an electrode layer in a predetermined pattern in a desired manner.

[0047]

Preferably, MW_L , MW_H and X are selected so that $X * MW_L +$
20 $(1-X) * MW_H$ falls within a range of 155,000 to 205,000.

[0048]

As the conductive material used for preparing the conductive paste, Ni, Ni alloy or the mixture thereof is preferably used. The shape of the conductive material is not particularly limited. The conductive material
25 particles may have a spherical shape or a scale-like shape, or the conductive material may contain spherical conductive material particles and scale-like conductive material particles. The average particle diameter of the conductive material is not particularly limited but a

conductive material having an average particle diameter of about 0.1 μm to about 2 μm is normally used for preparing the electrode paste and the conductive material having an average particle diameter of about 0.2 μm to about 1 μm is preferably used for preparing the electrode paste.

5 [0049]

The conductive paste preferably contains the binder in an amount about 2.5 weight parts to about 20 weight parts with respect to 100 weight parts of the conductive material.

[0050]

10 The content of the solvent is preferably about 40 weight % to about 60 weight % with respect to the weight of the conductive paste.

[0051]

In order to improve adhesion property, it is preferable for the conductive paste to contain a plasticizing agent. The plasticizing agent
15 contained in the conductive paste is not particularly limited and illustrative examples thereof include phthalate ester, adipic acid, phosphate ester, glycols and the like. The conductive paste contains the plasticizing agent preferably in an amount of about 10 weight % to about 300 weight % with respect to 100 weight parts of the binder, more
20 preferably in an amount of about 10 weight parts to about 200 weight parts. In the case where the amount of the plasticizing agent added to the conductive paste is too large, the strength of the electrode layer tends to be markedly lower.

[0052]

25 As occasion demands, the conductive paste may contain additives selected from among various dispersing agents accessory ingredient compounds and the like.

[0053]

In the present invention, preferably, prior to forming an electrode layer or after forming an electrode layer and drying it, a dielectric paste adapted for forming a spacer layer and containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and
5 ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl
10 methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate is printed on the surface of a ceramic green sheet in a complementary pattern to that of the electrode layer using a screen printing machine, a gravure printing machine or the like, thereby forming
15 a spacer layer.

[0054]

In the case where a spacer layer is formed on the surface of a ceramic green sheet in a complementary pattern to that of the electrode layer in this manner, it is possible to prevent a step from being formed
20 between the surface of the electrode layer and the surface of the ceramic green sheet where no electrode layer is formed. Therefore, even in the case of laminating a number of multi-layered units each including a ceramic green sheet and an electrode layer and fabricating a multi-layered electronic component such as a multi-layered ceramic
25 capacitor, it is possible to effectively prevent the thus fabricated multi-layered electronic component from being deformed and also effectively prevent delamination of layers from occurring.

[0055]

Furthermore, as described above, since the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves the acrylic system resin contained in the ceramic green sheet as a binder, it is possible to reliably prevent the ceramic green sheet from being swollen or partially dissolved so as to generate voids at the interface between the ceramic green sheet and the spacer layer or generate fissures or wrinkles on the surface of the spacer layer.

[0056]

Moreover, since the dielectric paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate has a viscosity suitable for printing, a spacer layer can be formed on a ceramic green sheet in a complimentary pattern to that of the electrode layer in a desired manner using a screen printing machine, a gravure printing machine or the like.

[0057]

In this embodiment, the dielectric paste for forming the spacer layer is prepared in the similar manner to the dielectric paste for forming the ceramic green sheet except that different binder and solvent are used.

[0058]

Then, the electrode layer or the electrode layer and the spacer layer are dried and a multi-layered unit including the ceramic green sheet and electrode layer or the electrode layer and the spacer layer laminated
5 on the support sheet is fabricated.

[0059]

When a multi-layered ceramic capacitor is to be fabricated, the support sheet is peeled off from the ceramic green sheet of the multi-layered unit and the multi-layered unit is diced to predetermined
10 dimensions. Then, a predetermined number of the multi-layered units are laminated on the outer layer of a multi-layered ceramic capacitor and the other outer layer of a multi-layered ceramic capacitor is further laminated on the multi-layered units, thereby fabricating a laminated body. Next, the thus obtained laminated body is press molded and diced to
15 predetermined dimensions, thereby fabricating ceramic green chips.

[0060]

The thus fabricated ceramic green chips are placed in a reducing gas atmosphere so that the binder is removed therefrom and the ceramic green chips are baked.

20 [0061]

Necessary external electrodes are then attached to the thus baked ceramic green chip, thereby manufacturing a multi-layered ceramic capacitor.

[0062]

25 According to this embodiment, since the electrode layer is formed by printing the conductive paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight

ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate on the ceramic green sheet containing an acrylic system resin as a binder in a predetermined pattern and the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves the acrylic system resin contained in a ceramic green sheet as a binder. As a result, even in the case of printing the conductive paste on a very thin ceramic green sheet, thereby forming an electrode layer, it is possible to reliably prevent the binder contained in the ceramic green sheet from being dissolved by the solvent contained in the conductive paste and the ceramic green sheet from being swollen or partially dissolved. Therefore, even in the case where a ceramic green sheet is very thin, it is possible to effectively prevent generation of pinholes or cracks in the ceramic green sheet and it is therefore possible to effectively prevent short circuit failure from occurring in a multi-layered ceramic capacitor fabricated by laminating a number of multi-layered units.

[0063]

Further, according to this embodiment, the spacer layer is formed by printing the dielectric paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight

ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate on the ceramic green sheet containing an acrylic system resin as a binder in a complementary pattern to that of the electrode layer and the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves the acrylic system resin contained in a ceramic green sheet as a binder. As a result, even in the case of printing the dielectric paste on a very thin ceramic green sheet, thereby forming a spacer layer, it is possible to reliably prevent the binder contained in the ceramic green sheet from being dissolved by the solvent contained in the dielectric paste and the ceramic green sheet from being swollen or partially dissolved so as to generate voids at the interface between the ceramic green sheet and the spacer layer or generate fissures or wrinkles on the surface of the spacer layer. Therefore, in the case where a multi-layered ceramic capacitor is fabricated by laminating a number of multi-layered units each including a ceramic green sheet and an electrode layer, it is possible to reliably prevent voids from being generated in the multi-layered ceramic capacitor and it is also possible to reliably prevent the portions of the spacer layer where fissures or wrinkles are generated from dropping off during lamination of a number of the multi-layered units to fabricate the laminated body and mixing into the laminated body

as a foreign substance so as to cause internal defects in the multi-layered ceramic capacitor.

[0064]

In another preferred embodiment of the present invention, a
5 second support sheet is provided separately from the long support sheet
used for forming the ceramic green sheet and the surface of the long
second support sheet is coated using a wire bar coater or the like with a
dielectric paste containing particles of a dielectric material having
substantially the same composition as that of the dielectric material
10 contained in the ceramic green sheet and the same binder as that
contained in the ceramic green sheet, thereby forming a coating layer and
the coating layer is dried to form a release layer.

[0065]

As the second support sheet, a polyethylene terephthalate film is
15 employed, for example, and the surface of the second support sheet may
be coated with a silicon resin, an alkyd resin or the like in order to
improve the releasability thereof.

[0066]

The thickness of the release layer is preferably equal to or thinner
20 than that of an electrode layer, more preferably equal to or thinner than
about 60 % of the electrode layer thickness and most preferably equal to
or thinner than about 30 % of the electrode layer thickness.

[0067]

After the release layer has been dried, the conductive paste for an
25 electrode layer prepared in the above described manner is printed on the
surface of the release layer in a predetermined pattern using a screen
printing machine, a gravure printing machine or the like, thereby forming
an electrode layer.

[0068]

It is preferable to form the electrode layer so as to have a thickness of about 0.1 μm to about 5 μm and it is more preferable to form the electrode layer so as to have a thickness of about 0.1 μm to about 1.5 μm .

5 [0069]

In this embodiment, the conductive paste contains a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and
15 acetoxy-methoxyethoxy-cyclohexanol acetate.

[0070]

Since the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl
20 acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves an acrylic system resin contained in a ceramic green sheet as a binder, even in the case of forming a release layer containing the same binder as that of the ceramic green sheet and printing the conductive paste on the release
25 layer to form an electrode layer, it is possible to effectively prevent the release layer from being swollen or partially dissolved so as to generate voids at the interface between the release layer and the electrode layer or generate fissures or wrinkles on the surface of the electrode layer.

[0071]

Further, since the conductive paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate has a viscosity suitable for printing, an electrode layer can be formed on the release layer in a predetermined pattern using a screen printing machine, a gravure printing machine or the like in a desired manner.

[0072]

Preferably, MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 155,000 to 205,000.

[0073]

In the present invention, preferably, prior to forming an electrode layer or after forming an electrode layer and drying it, a dielectric paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and

acetoxy-methoxyethoxy-cyclohexanol acetate and prepared in the above described manner is printed on the surface of the release layer in a complementary pattern to that of the electrode layer using a screen printing machine, a gravure printing machine or the like, thereby forming
5 a spacer layer.

[0074]

In the case where the spacer layer is formed on the surface of a release layer in a complementary pattern to that of the electrode layer in this manner, it is possible to prevent a step from being formed between
10 the surface of the electrode layer and the surface of the release layer where no electrode layer is formed. Therefore, even in the case of laminating a number of multi-layered units each including a ceramic green sheet and an electrode layer and fabricating a multi-layered electronic component such as a multi-layered ceramic capacitor, it is
15 possible to effectively prevent the thus fabricated multi-layered electronic component from being deformed and also effectively prevent delamination of layers from occurring.

[0075]

Further, as described above, since the solvent selected from the
20 group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillylalcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves the acrylic system resin contained in the ceramic green sheet as a binder, even in the
25 case of forming the release layer containing the same binder as that of the ceramic green sheet and printing a dielectric paste on the release layer to form a spacer layer, it is possible to effectively prevent the release layer from being swollen or partially dissolved so as to generate voids at the

interface between the release layer and the spacer layer or generate fissures or wrinkles on the surface of the spacer layer.

[0076]

Further, since the dielectric paste containing a binder containing
5 ethyl cellulose having a weight average molecular weight of MW_L and
ethyl cellulose having a weight average molecular weight of MW_H at a
weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X * MW_L + (1-X) * MW_H$ falls within a range of 110,000 to 180,000 and at least
one solvent selected from the group consisting of isobornyl acetate,
10 dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl
methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate,
I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol
acetate has a viscosity suitable for printing, a spacer layer can be formed
on the surface of the release layer in a complementary pattern to that of
15 the electrode layer using a screen printing machine, a gravure printing
machine or the like in a desired manner.

[0077]

Further, a long third support sheet is provided and the surface of
the third support sheet is coated with an adhesive agent solution using a
20 bar coater, an extrusion coater, a reverse coater, a dip coater, a kiss coater
or the like and the coating layer is dried, thereby forming an adhesive
layer.

[0078]

It is preferable for the adhesive agent solution to contain a binder
25 belonging to the same group as that the binder contained in the ceramic
green sheet belongs to, particles of a dielectric material having
substantially the same composition as that of dielectric particles
contained in the ceramic green sheet, a plasticizing agent, an antistatic

agent and a release agent.

[0079]

It is preferable to form an adhesive layer so as to have a thickness thinner than about 0.3 μm , more preferable to form it so as to have a thickness of about 0.02 μm to about 0.3 μm and particularly preferable to form it so as to have a thickness of about 0.02 μm to about 0.2 μm .

[0080]

The adhesive layer formed on the long third support sheet in this manner is bonded onto the surface of the electrode layer or the surfaces of the electrode layer and the spacer layer formed on the long second support sheet or the surface of the ceramic green sheet formed on the support sheet and the third support sheet then is peeled off from the adhesive layer, whereby the adhesive layer is transferred onto the surface of the electrode layer or the surfaces of the electrode layer and the spacer layer or the surface of the ceramic green sheet.

[0081]

In the case where the adhesive layer is transferred onto the surface of the electrode layer or the surfaces of the electrode layer and the spacer layer, the ceramic green sheet formed on the long support sheet is bonded onto the adhesive layer and the first support sheet is peeled off from the ceramic green sheet so that the ceramic green sheet is transferred onto the surface of the adhesive layer, thereby fabricating a multi-layered unit including the ceramic green sheet and the electrode layer or the electrode layer and the spacer layer.

[0082]

An adhesive layer is transferred onto the surface of the ceramic green sheet of the thus fabricated multi-layered unit in a similar manner to that of transferring the adhesive layer onto the surface of the electrode

layer or the surfaces of the electrode layer and the spacer layer and the multi-layered unit including the adhesive layer transferred onto the surface thereof is diced to predetermined dimensions.

[0083]

5 Similarly, a predetermined number of multi-layered units each including the adhesive layer transferred onto the surface thereof are fabricated and the predetermined number of multi-layered units are laminated, thereby fabricating a multi-layered block.

[0084]

10 When a multi-layered block is to be fabricated, the multi-layered unit is first positioned on a support formed of polyethylene terephthalate or the like in such a manner that the adhesive layer transferred onto the surface of the multi-layered unit comes into contact with the support and the multi-layered unit is pressed by a pressing machine or the like,
15 whereby the multi-layered unit is bonded onto the support via the adhesive layer.

[0085]

Afterwards, the second support sheet is peeled off from the release layer and the multi-layered unit is laminated on the support.

20 [0086]

Then, a new multi-layered unit is positioned on the surface of the release layer of the multi-layered unit laminated on the support in such a manner that an adhesive layer formed on the new multi-layered unit comes into contact with the surface of the release layer and the
25 multi-layered unit is pressed using a pressing machine or the like, whereby the new multi-layered unit is laminated on the surface of the release layer of the multi-layered unit laminated on the support via the adhesive layer. Afterwards, the second support sheet is peeled off from the

release layer of the new multi-layered unit.

[0087]

Similar processes are repeated, thereby fabricating a multi-layered block including a predetermined number of the laminated multi-layered units.

[0088]

On the other hand, in the case where the adhesive layer is transferred onto the surface of the ceramic green sheet, the electrode layer or the electrode layer and the spacer layer formed on the second support sheet are bonded onto the adhesive layer and then, the second support sheet is peeled off from the release layer, the electrode layer or the electrode layer and the spacer layer and the release layer are transferred onto the surface of the adhesive layer. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer is fabricated.

[0089]

An adhesive layer is transferred onto the surface of the release layer of the thus obtained multi-layered unit in a similar manner to that of transferring the adhesive layer onto the surface of the ceramic green sheet and the multi-layered unit including the adhesive layer transferred onto the surface thereof is diced to predetermined dimensions.

[0090]

Similarly, a predetermined number of multi-layered units each including the adhesive layer transferred onto the surface thereof are fabricated and the predetermined number of multi-layered units are laminated, thereby fabricating a multi-layered block.

[0091]

When a multi-layered block is to be fabricated, the multi-layered

unit is first positioned on a support formed of polyethylene terephthalate or the like in such a manner that the adhesive layer transferred onto the surface of the multi-layered unit comes into contact with the support and the multi-layered unit is pressed by a pressing machine or the like, whereby the multi-layered unit is bonded onto the support via the adhesive layer.

[0092]

Afterwards, the support sheet is peeled off from the ceramic green sheet and the multi-layered unit is laminated on the support.

[0093]

Then, a new multi-layered unit is positioned on the surface of the ceramic green sheet of the multi-layered unit laminated on the support in such a manner that an adhesive layer formed on the new multi-layered unit comes into contact with the surface of the ceramic green sheet and the multi-layered unit is pressed using a pressing machine or the like, whereby the new multi-layered unit is laminated on the surface of the ceramic green sheet of the multi-layered unit laminated on the support via the adhesive layer. Afterwards, the support sheet is peeled off from the release layer of the new multi-layered unit.

[0094]

Similar processes are repeated, thereby fabricating a multi-layered block including a predetermined number of the laminated multi-layered units.

[0095]

The thus fabricated multi-layered block including the predetermined number of the laminated multi-layered units is laminated on the outer layer of a multi-layered ceramic capacitor and the other outer layer of a multi-layered ceramic capacitor is further laminated on the

multi-layered block, thereby fabricating a laminated body. Next, the thus obtained laminated body is press molded and diced to predetermined dimensions, thereby fabricating a number of ceramic green chips.

[0096]

5 The thus fabricated ceramic green chips are placed in a reducing gas atmosphere so that the binder is removed therefrom and the ceramic green chips are baked.

[0097]

10 Necessary external electrodes are then attached to the thus baked ceramic green chip, thereby manufacturing a multi-layered ceramic capacitor.

[0098]

15 According to this preferred embodiment, since the electrode layer and the spacer layer formed on the second support sheet are dried and then bonded onto the surface of the ceramic green sheet via the adhesive layer, unlike in the case of printing a conductive paste on the surface of the ceramic green sheet to form an electrode layer and printing a dielectric paste on the surface of the ceramic green sheet to form a spacer layer, it is possible to prevent the conductive paste and the dielectric
20 paste from permeating into the ceramic green sheet and it is therefore possible to laminate the electrode layer and the spacer layer on the surface of the ceramic green sheet in a desired manner.

[0099]

25 Furthermore, according to this preferred embodiment, the electrode layer is formed using the conductive paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected

so that $X \cdot MW_L + (1-X) \cdot MW_H$ falls within a range of 145,000 to 215,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate and the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves an acrylic system resin contained in a ceramic green sheet as a binder. As a result, even in the case of forming the release layer containing the same binder as that contained in a ceramic green sheet and printing the conductive paste on the release layer, thereby forming an electrode layer, it is possible to effectively prevent the release layer from being swollen or partially dissolved so as to generate pinholes or cracks in the release layer and effectively prevent defects from being generated in a multi-layered ceramic capacitor.

[0100]

Further, according to this preferred embodiment, the spacer layer is formed using the dielectric paste containing a binder containing ethyl cellulose having a weight average molecular weight of MW_L and ethyl cellulose having a weight average molecular weight of MW_H at a weight ratio of $X : (1-X)$, where MW_L , MW_H and X are selected so that $X \cdot MW_L + (1-X) \cdot MW_H$ falls within a range of 110,000 to 180,000 and at least one solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate,

I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate and the solvent selected from the group consisting of isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol and acetoxy-methoxyethoxy-cyclohexanol acetate hardly dissolves an acrylic system resin contained in a ceramic green sheet as a binder. As a result, even in the case of forming a release layer containing the same binder as that contained in the ceramic green sheet and printing a dielectric paste on the surface of the release layer, thereby forming a spacer layer, it is possible to effectively prevent the release layer from being swollen or partially dissolved so as to generate voids at the interface between the release layer and the spacer layer or generate fissures or wrinkles on the surface of the spacer layer. Therefore, in the case where a multi-layered ceramic capacitor is fabricated by laminating a number of multi-layered units each including a ceramic green sheet and an electrode layer, it is possible to reliably prevent voids from being generated in the multi-layered ceramic capacitor and it is also possible to reliably prevent the portions of the spacer layer where fissures or wrinkles are generated from dropping off during lamination of a number of the multi-layered units to fabricate the laminated body and mixing into the laminated body as a foreign substance so as to cause internal defects in the multi-layered ceramic capacitor.

[0101]

Moreover, according to this preferred embodiment, since it is possible to prevent the release layer from being swollen or partially dissolved, thereby changing the release strength between the release layer and the electrode layer and the spacer layer or the release layer and

the electrode layer, it is possible to effectively prevent defects from being generated when a multi-layered unit is fabricated.

[0102]

In a further preferred embodiment, in the case where the adhesive
5 layer is transferred onto the surface of the electrode layer or the surfaces
of the electrode layer and the spacer layer, an adhesive layer is
transferred onto the surface of a ceramic green sheet of a multi-layered
unit fabricated by laminating a release layer, an electrode layer or an
electrode layer and a spacer layer, an adhesive layer and a ceramic green
10 sheet on a long second support sheet and without cutting the
multi-layered unit, a release layer of another multi-layered unit
fabricated by laminating a ceramic green sheet, an adhesive layer, an
electrode layer or an electrode layer and a spacer layer, and the release
layer on a long support sheet is bonded onto the adhesive layer and the
15 support sheet is peeled off from the ceramic green sheet, whereby two
multi-layered units are laminated on the long second support sheet.

[0103]

Then, an adhesive layer formed on a third support sheet is
transferred onto the ceramic green sheet located on the side of the surface
20 of the laminated two multi-layered units and a release layer of another
multi-layered unit fabricated by laminating a ceramic green sheet, an
adhesive layer, an electrode layer or an electrode layer and a spacer layer,
and the release layer on a long support sheet is bonded onto the adhesive
layer and the support sheet is peeled off from the release layer.

25 [0104]

Similar processes are repeated, thereby fabricating a
multi-layered unit set including a predetermined number of laminated
multi-layered units. Further, an adhesive layer formed on the third

support sheet is transferred onto the surface of the ceramic green sheet located on the side of the surface of the multi-layered unit set, thereby fabricating a laminated body and the laminated body is diced to predetermined dimensions, thereby fabricating a multi-layered blocks.

5 [0105]

On the other hand, in the case where the adhesive layer is transferred onto the surface of the ceramic green sheet, an adhesive layer is transferred onto the surface of a release layer of a multi-layered unit fabricated by laminating a ceramic green sheet, an adhesive layer, an electrode layer or an electrode layer and a spacer layer, and the release layer on a long support sheet and without cutting the multi-layered unit, a ceramic green sheet of another multi-layered unit fabricated by laminating a release layer, an electrode layer or an electrode layer and a spacer layer, an adhesive layer and a ceramic green sheet on a long second support sheet is bonded onto the adhesive layer and the second support sheet is peeled off from the release layer, whereby two multi-layered units are laminated on the long second support sheet.

[0106]

Then, an adhesive layer formed on a third support sheet is transferred onto the release layer located on the side of the surface of the laminated two multi-layered units and a ceramic green sheet of a multi-layered unit fabricated by laminating a release layer, an electrode layer or an electrode layer and a spacer layer, an adhesive layer and a ceramic green sheet on a long second support sheet is further laminated on the adhesive layer. Then, the second support sheet is peeled off from the release layer.

[0107]

Similar processes are repeated, thereby fabricating a

multi-layered unit set including a predetermined number of laminated multi-layered units. Further, an adhesive layer formed on the third support sheet is transferred onto the surface of the release layer located on the side of the surface of the multi-layered unit set, thereby fabricating a laminated body and the laminated body is diced to predetermined dimensions, thereby fabricating multi-layered blocks.

[0108]

A multi-layered ceramic capacitor is fabricated using the thus fabricated multi-layered blocks in the manner of the previous preferred embodiment.

[0109]

According to this preferred embodiment, since the multi-layered units are successively laminated on the long second support sheet or support sheet, thereby fabricating the multi-layered unit set including a predetermined number of multi-layered units and the multi-layered unit set is diced to predetermined dimensions, thereby fabricating multi-layered blocks, it is possible to markedly improve the manufacturing efficiency of the multi-layered blocks in comparison with the case where multi-layered blocks are fabricated by laminating multi-layered units each of which has been diced to predetermined dimensions.

[0110]

In a further preferred embodiment of the present invention, in the case where the adhesive layer is transferred onto the surface of the electrode layer or the surfaces of the electrode layer and the spacer layer, an adhesive layer is transferred onto the surface of a ceramic green sheet of a multi-layered unit fabricated by laminating a release layer, an electrode layer or an electrode layer and a spacer layer, an adhesive layer

and a ceramic green sheet on a long second support sheet and without cutting the multi-layered unit, an electrode layer or an electrode layer and a spacer layer formed on the second support sheet are bonded onto the adhesive layer and the second support sheet is peeled off from the release layer, whereby the electrode layer and the spacer layer, and the
5 release layer are transferred onto the surface of the adhesive layer.

[0111]

Then, an adhesive layer formed on a third support sheet is transferred onto the surface of the release layer transferred onto the adhesive layer, a ceramic green sheet formed on the support sheet is
10 bonded onto the adhesive layer and the support sheet is peeled off from the ceramic green sheet, whereby the ceramic green sheet is transferred onto the surface of the adhesive layer.

[0112]

Further, an adhesive layer formed on a third support sheet is transferred onto the surface of the ceramic green sheet transferred onto the surface of the adhesive layer, an electrode layer or an electrode layer and a spacer layer formed on the second support sheet are bonded onto the adhesive layer and the second support sheet is peeled off from the
20 release layer, whereby the electrode layer or the electrode layer and the spacer layer, and the release layer are transferred onto the surface of the adhesive layer.

[0113]

Similar processes are repeated, thereby fabricating a
25 multi-layered unit set including a predetermined number of laminated multi-layered units. Further, an adhesive layer formed on the third support sheet is transferred onto the surface of the ceramic green sheet located on the side of the surface of the multi-layered unit set, thereby

fabricating a laminated body and the laminated body is diced to predetermined dimensions, thereby fabricating multi-layered blocks.

[0114]

On the other hand, in the case where the adhesive layer is transferred onto the surface of the ceramic green sheet, an adhesive layer is transferred onto the surface of a release layer of a multi-layered unit fabricated by laminating a ceramic green sheet, an adhesive layer, an electrode layer or an electrode layer and a spacer layer, and the release layer on a long support sheet and without cutting the multi-layered unit, a ceramic green sheet of a support sheet is bonded onto the adhesive layer and the support sheet is peeled off from the ceramic green sheet, whereby the ceramic green sheet is transferred onto the adhesive layer.

[0115]

Further, an adhesive layer formed on the third support sheet is transferred onto the ceramic green sheet transferred onto the adhesive layer and an electrode layer or an electrode layer and a spacer layer formed on the second support sheet are bonded onto the adhesive layer. Then, the second support sheet is peeled off from the release layer, whereby the electrode layer or the electrode layer and the spacer layer, and the release layer are transferred onto the surface of the adhesive layer.

[0116]

Further, an adhesive layer formed on the third support sheet is transferred onto the release layer transferred onto the adhesive layer and a ceramic green sheet formed on the support sheet is bonded onto the adhesive layer. Then, the support sheet is peeled off from the ceramic green sheet, whereby the ceramic green sheet is transferred onto the surface of the adhesive layer.

[0117]

Similar processes are repeated, thereby fabricating a multi-layered unit set including a predetermined number of laminated multi-layered units. Further, an adhesive layer is transferred onto the surface of the release layer located on the side of the surface of the multi-layered unit set, thereby fabricating a laminated body and the laminated body is diced to predetermined dimensions, thereby fabricating multi-layered blocks.

[0118]

A multi-layered ceramic green sheet is fabricated using the thus fabricated multi-layered block in the manner of the previous embodiment.

[0119]

According to this preferred embodiment, the transferring of the adhesive layer, the transferring of the electrode layer or the electrode layer and the spacer layer and the release layer, the transferring of the adhesive layer and the transferring of the ceramic green sheet onto the long second support sheet or support sheet are repeated, thereby successively laminating the multi-layered units to fabricate the multi-layered unit set including a predetermined number of multi-layered units and the multi-layered unit set is diced to predetermined dimensions, thereby fabricating multi-layered blocks. As a result, it is possible to markedly improve the manufacturing efficiency of the multi-layered block in comparison with the case where multi-layered blocks are fabricated by laminating multi-layered units each of which has been diced to predetermined dimensions.

[0120]

Hereinafter, working examples and comparative examples will be set out in order to further clarify the advantages of the present invention.

[WORKING EXAMPLES]

[0121]

Working Example 1

5 Preparation of a dielectric paste for forming a ceramic green sheet

1.48 weight parts of $(\text{BaCa})\text{SiO}_3$, 1.01 weight parts of Y_2O_3 , 0.72 weight part of MgCO_3 , 0.13 weight part of MnO and 0.045 weight part of V_2O_5 were mixed, thereby preparing an additive powder.

[0122]

10 159.3 weight parts of ethyl cellulose and 0.93 weight parts of polyethylene glycol system dispersing agent were added to 100 weight parts of the thus prepared additive powder to prepare a slurry and the additives contained in the slurry were pulverized.

[0123]

15 When the additives contained in the slurry were to be pulverized, 11.65 grams of the slurry and 450 grams of ZrO_2 beads having a diameter of 2 mm were charged in a polyethylene vessel having an inner volume of 250 cc and the polyethylene vessel was rotated at the circumferential velocity of 45 m/min for sixteen hours, thereby pulverizing the additive
20 powder to prepare the additive slurry.

[0124]

The median diameter of the additives after pulverization was 0.1 μm .

[0125]

25 Then, 15 weight parts of a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and T_g was 70 °C was dissolved into 85 weight parts of ethyl

acetate at 50 °C, thereby preparing an organic vehicle solution of 8 %. Further, a slurry having the composition set out below was mixed with the organic vehicle solution for twenty hours using a polyethylene vessel having an inner volume of 500 cc, thereby preparing a dielectric paste.

5 When the slurry was to be mixed with the organic vehicle solution, 344.1 grams of the slurry and 900 grams of ZrO₂ beads having a diameter of 2 mm were charged in the polyethylene vessel and the polyethylene vessel was rotated at the circumferential velocity of 45 m/min.

[0126]

10 BaTiO₃ powder ("BT-02" (Product Name) manufactured by SAKAI CHEMICAL INDUSTRY CO., LTD.: particle diameter 0.2 μm)

		100 weight parts
	additive slurry	11.2 weight parts
	ethyl acetate	163.76 weight parts
15	toluene	21.48 weight parts
	polyethylene glycol system dispersing agent	1.04 weight parts
	antistatic auxiliary agent	0.83 weight parts
	diacetone alcohol	1.04 weight parts
	benzyl butyl phthalate (plasticizing agent)	2.61 weight parts
20	butyl stearate	0.52 weight parts
	mineral sprit	6.78 weight parts
	organic vehicle	34.77 weight parts

As a polyethylene glycol system dispersing agent, a dispersing

25 agent which was obtained by denaturing polyethylene glycol with aliphatic acid and whose hydrophile-lipophile balance (HLB) was 5 to 6 was employed and as an antistatic auxiliary agent, polyethylene glycol whose average molecular weight was 400.

[0127]

Formation of a ceramic green sheet

A polyethylene terephthalate film was coated with the thus prepared dielectric paste using a die coater at a coating velocity of 50
5 m/minutes, thereby forming a coating layer and the thus formed coating layer was dried in a drying furnace whose temperature was held at 80 °C, thereby forming a ceramic green sheet having a thickness of 1 µm.

[0128]

Preparation of a conductive paste for forming an electrode layer

10 1.48 weight parts of (BaCa)SiO₃, 1.01 weight parts of Y₂O₃, 0.72 weight part of MgCO₃, 0.13 weight part of MnO and 0.045 weight part of V₂O₅ were mixed, thereby preparing an additive powder.

[0129]

15 150 weight parts of acetone, 104.3 weight parts of isobornyl acetate and 1.5 weight parts of polyethylene glycol system dispersing agent were added to 100 weight parts of the thus prepared additive powder to prepare a slurry and the additives contained in the slurry were pulverized using a pulverizer "LMZ0.6" (Product name) manufactured by Ashizawa Finetech Co., Ltd.

20 [0130]

When the additives contained in the slurry were to be pulverized, ZrO₂ beads having a diameter of 0.1 mm were charged into a vessel so as to occupy 80 volume % of the vessel, the vessel was rotated at the circumferential velocity of 14 m/min and the slurry was circulated
25 between the vessel and a slurry tank until holding time of the whole slurry of two liters became 30 minutes, thereby pulverizing the additives contained in the slurry.

[0131]

The median diameter of the additives after pulverization was 0.1 μm .

[0132]

Then, acetone was evaporated using an evaporator and removed
5 from the slurry, thereby preparing an additive paste in which the
additives were dispersed in terpineol. The concentration of the additives
contained in the additive paste was 49.3 weight %.

[0133]

Then, 8 weight parts of a binder containing ethyl cellulose having
10 a weight average molecular weight (MW_H) of 230,000 and ethyl cellulose
having a weight average molecular weight (MW_L) of 130,000 at a weight
ratio of 75:25, namely, 8 weight parts of ethyl cellulose having an
apparent weight average molecular weight of 205,000 defined as $X \cdot MW_L$
+ $(1-X) \cdot MW_H$, was dissolved in 92 weight parts of isobornyl acetate at 70
15 $^{\circ}\text{C}$, thereby preparing an 8 % organic vehicle solution. Further, a slurry
having the composition set out below was dispersed in the organic vehicle
solution for sixteen hours using a ball mill. The dispersing conditions
were set so that the amount of charged ZrO_2 having a diameter of 2.0 mm
was 30 volume % of the ball mill, the amount of the slurry in the ball mill
20 was 60 volume % and the circumferential velocity of the ball mill was 45
m/min.

[0134]

nickel powder manufactured by Kawatetsu Industry Co., Ltd. and having a particle diameter of 0.2 μm	100 weight parts
25 additive paste	1.77 weight parts
BaTiO_3 powder manufactured by SAKAI CHEMICAL INDUSTRY CO., LTD.	19.14 weight parts
organic vehicle	56.25 weight parts

polyethylene glycol system dispersing agent	1.19 weight parts
isobornyl acetate	32.19 weight parts
acetone	56 weight parts

5 Then, acetone was evaporated using a stirring device having an evaporator and a heating mechanism and removed from the slurry, thereby preparing a conductive paste. The concentration of the dielectric material contained in the conductive paste was 47 weight %.

[0135]

10 The viscosity of the thus obtained conductive paste was measured using a rheometer manufactured by HAAKE Co., Ltd. under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

15 [0136]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 19.4 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 10.4 Ps·s.

20 [0137]

Formation of an electrode layer and fabrication of a multi-layered unit

The thus prepared conductive paste was printed on the ceramic green sheet using a screen printing machine and dried at 90 °C for five minutes, thereby forming an electrode layer having a thickness of 1 μm.

25 Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0138]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.143 μm and that
5 the electrode layer having a high surface smoothness was formed.

[0139]

Fabrication of a ceramic green chip

The surface of a polyethylene terephthalate film was coated with the dielectric paste prepared in the above described manner using a die
10 coater, thereby forming a coating layer, and the coating layer was dried, thereby forming a ceramic green sheet having a thickness of 10 μm .

[0140]

The thus formed ceramic green sheet was peeled off from the polyethylene terephthalate film and diced. Five of the diced ceramic green
15 sheet units were laminated to form a cover layer having a thickness of 50 μm . Further, the multi-layered unit was peeled off from the polyethylene terephthalate film and diced and fifty of the diced multi-layered units were laminated on the cover layer.

[0141]

20 Then, the ceramic green sheet having a thickness of 10 μm was peeled off from the polyethylene terephthalate film and diced and five of the ceramic green sheet units were laminated on the multi-layered units laminated on the cover layer, thereby fabricating a laminated body including the lower cover layer having a thickness of 50 μm , an active
25 layer having a thickness of 100 μm and including the laminated fifty multi-layered units each including the ceramic green sheet having a thickness of 1 μm and the electrode layer having a thickness of 1 μm , and an upper cover layer having a thickness of 50 μm .

[0142]

Further, a pressure of 100 MPa was applied onto the thus fabricated laminated body at 70 °C, thereby press molding the laminated body and the laminated body was diced to predetermined dimensions
5 using a dicing machine, thereby fabricating ceramic green chips.

[0143]

Fabrication of a multi-layered ceramic capacitor sample

The thus fabricated ceramic green chip was processed under the following conditions in an air atmosphere to remove the binder.

10 [0144]

Rate of temperature increase: 50 °C / hour

Holding temperature: 240 °C

Holding time period: 8 hours

After removing the binder, the ceramic green chip was processed
15 and baked under the following conditions in a mixed gas atmosphere of a nitrogen gas and a hydrogen gas whose temperature was controlled at the dew point 20 °C. The contents of the nitrogen gas and the hydrogen gas contained in the mixed gas were 95 volume % and 5 volume %, respectively.

20 [0145]

Rate of temperature increase: 300 °C / hour

Holding temperature: 1200 °C

Holding time period: 2 hours

Cooling rate: 300 °C / hour

25 The thus baked ceramic green chip was subjected to an annealing treatment under the following conditions in a nitrogen gas atmosphere whose temperature was controlled at the dew point 20 °C.

[0146]

Rate of temperature increase: 300 °C / hour

Holding temperature: 1000 °C

Holding time period: 3 hours

Cooling rate: 300 °C / hour

5 End surfaces of the thus obtained sintered body were polished by the sandblast and coated with In-Ga alloy, thereby forming a terminal electrode. Thus, a multi-layered ceramic capacitor sample was fabricated.

[0147]

A total of fifty multi-layered ceramic capacitor samples were
10 fabricated in a manner similar to the foregoing.

[0148]

Measurement of a short-circuit failure ratio

The resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter to check
15 whether or not short-circuit failure occurred therein.

[0149]

In the case where the thus measured resistance value was equal to or lower than 100 K Ω , it was judged that short-circuit failure occurred in the multi-layered ceramic capacitor sample. The number of the ceramic
20 capacitor samples in which short-circuit failure occurred was measured and the ratio of the number of the ceramic capacitor samples in which short-circuit failure occurred to the total number of the fabricated multi-layered ceramic capacitor samples was calculated and defined as the short-circuit failure ratio.

25 [0150]

As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 18 %, so that the risk of short-circuit failure could be considered insignificant from the practical

viewpoint.

[0151]

Working Example 2

A conductive paste was prepared in the manner of Working
5 Example 1 except that a binder containing ethyl cellulose having a weight
average molecular weight (MW_H) of 230,000 and ethyl cellulose having a
weight average molecular weight (MW_L) of 130,000 at a weight ratio of
50:50, namely, ethyl cellulose having an apparent weight average
molecular weight of 180,000 defined as $X \cdot MW_L + (1-X) \cdot MW_H$, was used
10 and the viscosity of the thus prepared conductive paste was measured
under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹
and was also measured under conditions of a temperature of 25 °C and
shearing velocity of 50 sec⁻¹.

[0152]

15 As a result, it was found that the viscosity of the conductive paste
measured under condition of the shearing velocity of 8 sec⁻¹ was 15.5 Ps·s
and that the viscosity of the conductive paste measured under condition of
the shearing velocity of 50 sec⁻¹ was 8.5 Ps·s.

[0153]

20 Then, the thus prepared conductive paste was printed on a ceramic
green sheet fabricated in the manner of Working Example 1 using a
screen printing machine, thereby forming an electrode layer having a
thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
sheet and the electrode layer laminated on the polyethylene terephthalate
25 film was fabricated.

[0154]

The surface roughness (R_a) of the thus formed electrode layer was
measured using the "SURFCORDER (SE-30D)" (Product Name)

manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.088 μm and that the electrode layer having a high surface smoothness was formed.

5 [0155]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not
10 short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 8 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0156]

15 Working Example 3

A conductive paste was prepared in the manner of Working Example 1 except that a binder containing ethyl cellulose having a weight average molecular weight (MW_H) of 230,000 and ethyl cellulose having a weight average molecular weight (MW_L) of 130,000 at a weight ratio of
20 25:75, namely, ethyl cellulose having an apparent weight average molecular weight of 155,000 defined as $X \cdot MW_L + (1-X) \cdot MW_H$, was used and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and
25 shearing velocity of 50 sec^{-1} .

[0157]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 11.2 $\text{Ps} \cdot \text{s}$

and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec^{-1} was $6.8 \text{ Ps}\cdot\text{s}$.

[0158]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of $1 \text{ }\mu\text{m}$. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

10 [0159]

The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was $0.065 \text{ }\mu\text{m}$ and that the electrode layer having a high surface smoothness was formed.

[0160]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 6 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

25 [0161]

Working Example 4

A conductive paste was prepared in the manner of Working

Example 1 except that dihydroterpinyl methyl ether was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under
5 conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0162]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 16.1 Ps·s and that the viscosity of the conductive paste measured under condition of
10 the shearing velocity of 50 sec⁻¹ was 9.3 Ps·s.

[0163]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a
15 thickness of 1 µm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0164]

The surface roughness (Ra) of the thus formed electrode layer was
20 measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.132 µm and that the electrode layer having a high surface smoothness was formed.

25 [0165]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a

multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 16 %, so that the risk of short-circuit failure could be considered insignificant
5 from the practical viewpoint.

[0166]

Working Example 5

A conductive paste was prepared in the manner of Working Example 4 except that a binder containing ethyl cellulose having a weight
10 average molecular weight (MW_H) of 230,000 and ethyl cellulose having a weight average molecular weight (MW_L) of 130,000 at a weight ratio of 50:50 was used and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a
15 temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0167]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 12.3 $\text{Ps}\cdot\text{s}$ and that the viscosity of the conductive paste measured under condition of
20 the shearing velocity of 50 sec^{-1} was 7.3 $\text{Ps}\cdot\text{s}$.

[0168]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a
25 thickness of 1 μm . Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0169]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.070 μm and that the electrode layer having a high surface smoothness was formed.

[0170]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 12 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0171]

Working Example 6

A conductive paste was prepared in the manner of Working Example 4 except that a binder containing ethyl cellulose having a weight average molecular weight (MW_H) of 230,000 and ethyl cellulose having a weight average molecular weight (MW_L) of 130,000 at a weight ratio of 25:75 was used and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0172]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 8.6 $\text{Ps}\cdot\text{s}$

and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec^{-1} was $5.3 \text{ Ps}\cdot\text{s}$.

[0173]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of $1 \mu\text{m}$. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

10 [0174]

The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was $0.068 \mu\text{m}$ and that the electrode layer having a high surface smoothness was formed.

[0175]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 12 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0176]

Working Example 7

A conductive paste was prepared in the manner of Working

Example 1 except that dihydroterpinyl oxyethanol was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under
5 conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0177]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 16.6 Ps·s and that the viscosity of the conductive paste measured under condition of
10 the shearing velocity of 50 sec⁻¹ was 9.6 Ps·s.

[0178]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a
15 thickness of 1 µm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0179]

The surface roughness (Ra) of the thus formed electrode layer was
20 measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.133 µm and that the electrode layer having a high surface smoothness was formed.

25 [0180]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a

multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 18 %, so that the risk of short-circuit failure could be considered insignificant
5 from the practical viewpoint.

[0181]

Working Example 8

A conductive paste was prepared in the manner of Working Example 3 except that dihydroterpinyl oxyethanol was used as a solvent
10 instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0182]

15 As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 13.3 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 7.7 Ps·s.

[0183]

20 Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate
25 film was fabricated.

[0184]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name)

manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.072 μm and that the electrode layer having a high surface smoothness was formed.

5 [0185]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not
10 short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 20 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0186]

15 Working Example 9

A conductive paste was prepared in the manner of Working Example 3 except that dihydroterpinyl oxyethanol was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25
20 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0187]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 8.9 $\text{Ps}\cdot\text{s}$
25 and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec^{-1} was 5.2 $\text{Ps}\cdot\text{s}$.

[0188]

Then, the thus prepared conductive paste was printed on a ceramic

green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm . Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0189]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.081 μm and that the electrode layer having a high surface smoothness was formed.

[0190]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 14 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0191]

Working Example 10

A conductive paste was prepared in the manner of Working Example 1 except that terpinyl methyl ether was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 $^{\circ}\text{C}$ and shearing velocity of 8 sec^{-1} and was also measured under

conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0192]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 16.2 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 9.4 Ps·s.

[0193]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0194]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.115 μm and that the electrode layer having a high surface smoothness was formed.

[0195]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 18 %, so that the risk of short-circuit failure could be considered insignificant

from the practical viewpoint.

[0196]

Working Example 11

A conductive paste was prepared in the manner of Working
5 Example 2 except that terpinyl methyl ether was used as a solvent
instead of isobornyl acetate and the viscosity of the thus prepared
conductive paste was measured under conditions of a temperature of 25
°C and shearing velocity of 8 sec⁻¹ and was also measured under
conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

10 [0197]

As a result, it was found that the viscosity of the conductive paste
measured under condition of the shearing velocity of 8 sec⁻¹ was 11.7 Ps·s
and that the viscosity of the conductive paste measured under condition of
the shearing velocity of 50 sec⁻¹ was 6.6 Ps·s.

15 [0198]

Then, the thus prepared conductive paste was printed on a ceramic
green sheet fabricated in the manner of Working Example 1 using a
screen printing machine, thereby forming an electrode layer having a
thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
20 sheet and the electrode layer laminated on the polyethylene terephthalate
film was fabricated.

[0199]

The surface roughness (Ra) of the thus formed electrode layer was
measured using the "SURFCORDER (SE-30D)" (Product Name)
25 manufactured by Kosaka Laboratory Ltd. in the manner of Working
Example 1. As a result, it was found that the surface roughness (Ra) of
the electrode layer was 0.068 μm and that the electrode layer having a
high surface smoothness was formed.

[0200]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 10 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

10 [0201]

Working Example 12

A conductive paste was prepared in the manner of Working Example 3 except that terpinyl methyl ether was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0202]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 8.3 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 4.9 Ps·s.

[0203]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate

film was fabricated.

[0204]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.060 μm and that the electrode layer having a high surface smoothness was formed.

[0205]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 14 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0206]

Working Example 13

A conductive paste was prepared in the manner of Working Example 2 except that terpinyl oxyethanol was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0207]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 10.3 $\text{Ps}\cdot\text{s}$

and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec^{-1} was $6.2 \text{ Ps}\cdot\text{s}$.

[0208]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of $1 \text{ }\mu\text{m}$. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

10 [0209]

The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was $0.071 \text{ }\mu\text{m}$ and that the electrode layer having a high surface smoothness was formed.

[0210]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 16 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

25 [0211]

Working Example 14

A conductive paste was prepared in the manner of Working

Example 2 except that d-dihydrocarveol was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0212]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 10.6 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 6.0 Ps·s.

[0213]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0214]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.075 μm and that the electrode layer having a high surface smoothness was formed.

[0215]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a

multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 18 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0216]

Working Example 15

A conductive paste was prepared in the manner of Working Example 2 except that I-menthyl acetate was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0217]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 10.6 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 5.8 Ps·s.

[0218]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0219]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name)

manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.071 μm and that the electrode layer having a high surface smoothness was formed.

5 [0220]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not
10 short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 14 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0221]

15 Working Example 16

A conductive paste was prepared in the manner of Working Example 2 except that l-citronellol was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing
20 velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0222]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 10.8 $\text{Ps}\cdot\text{s}$ and that the viscosity of the conductive paste measured under condition of
25 the shearing velocity of 50 sec^{-1} was 6.2 $\text{Ps}\cdot\text{s}$.

[0223]

Then, the thus prepared conductive paste was printed on a ceramic

green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm . Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0224]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.069 μm and that the electrode layer having a high surface smoothness was formed.

[0225]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 16 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0226]

Working Example 17

A conductive paste was prepared in the manner of Working Example 2 except that I-perillylalcohol was used as a solvent instead of isobornyl acetate and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a

temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0227]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 11.5 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 6.4 Ps·s.

[0228]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0229]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.072 μm and that the electrode layer having a high surface smoothness was formed.

[0230]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 20 %, so that the risk of short-circuit failure could be considered insignificant

from the practical viewpoint.

[0231]

Working Example 18

A conductive paste was prepared in the manner of Working
5 Example 2 except that acetoxy-methoxyethoxy-cyclohexanol acetate was
used as a solvent instead of isobornyl acetate and the viscosity of the thus
prepared conductive paste was measured under conditions of a
temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also
measured under conditions of a temperature of 25 °C and shearing
10 velocity of 50 sec⁻¹.

[0232]

As a result, it was found that the viscosity of the conductive paste
measured under condition of the shearing velocity of 8 sec⁻¹ was 16.3 Ps·s
and that the viscosity of the conductive paste measured under condition of
15 the shearing velocity of 50 sec⁻¹ was 8.9 Ps·s.

[0233]

Then, the thus prepared conductive paste was printed on a ceramic
green sheet fabricated in the manner of Working Example 1 using a
screen printing machine, thereby forming an electrode layer having a
20 thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
sheet and the electrode layer laminated on the polyethylene terephthalate
film was fabricated.

[0234]

The surface roughness (Ra) of the thus formed electrode layer was
25 measured using the "SURFCORDER (SE-30D)" (Product Name)
manufactured by Kosaka Laboratory Ltd. in the manner of Working
Example 1. As a result, it was found that the surface roughness (Ra) of
the electrode layer was 0.078 μm and that the electrode layer having a

high surface smoothness was formed.

[0235]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 18 %, so that the risk of short-circuit failure could be considered insignificant from the practical viewpoint.

[0236]

Comparative Example 1

A conductive paste was prepared in the manner of Working Example 1 except that ethyl cellulose having a weight average molecular weight of 230,000 was used as a binder of a conductive paste and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0237]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 23.2 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 12.1 Ps·s.

[0238]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a

thickness of 1 μm . Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0239]

5 The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was 0.230 μm , that is, the surface roughness of the
10 electrode layer was high, so that an electrode layer having a high surface smoothness could not be formed.

[0240]

It was reasonable to conclude that this was because the viscosity of the conductive paste at the shearing velocity of 50 sec^{-1} was too high to
15 print the conductive paste in a desired manner.

[0241]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a
20 multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 36 % and it was found that the short-circuit failure was very high.

[0242]

25 Comparative Example 2

A conductive paste was prepared in the manner of Working Example 1 except that ethyl cellulose having a weight average molecular weight of 130,000 was used as a binder of the conductive paste and the

viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

5 [0243]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 7.1 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 4.7 Ps·s.

10 [0244]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
15 sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0245]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name)
20 manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.070 μm, i.e., that the surface smoothness of the electrode layer was high. However, it was found that since the viscosity of the conductive paste at the shearing velocity of 50 sec⁻¹ was too low and
25 the fluidity of the conductive paste was too high, the conductive paste leaked from a screen printing plate and the electrode layer could not be formed in a desired pattern.

[0246]

Comparative Example 3

A dielectric paste for forming a ceramic green sheet was prepared in the manner of Working Example 1 except that a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, 5 copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 230,000 and T_g was 70 °C was used as a binder of the dielectric paste for forming a ceramic green sheet, thereby forming a ceramic green sheet.

[0247]

10 Further, a conductive paste was prepared in the manner of Working Example 2 and the viscosity of the thus prepared dielectric paste for forming a ceramic green sheet was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing 15 velocity of 50 sec⁻¹.

[0248]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 15.5 Ps·s and that the viscosity of the conductive paste measured under condition of 20 the shearing velocity of 50 sec⁻¹ was 9.8 Ps·s.

[0249]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a 25 thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0250]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.112 μm and that the electrode layer having a high surface smoothness was formed.

[0251]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in the manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 36 % and it was found that the short-circuit failure was so high that the samples were of no practical use.

[0252]

It is reasonable to conclude that this was because the weight-average molecular weight of the binder of the dielectric paste for forming the ceramic green sheet was 230,000, which is too low, so that part of the ceramic green sheet was swollen and dissolved by the solvent.

[0253]

Comparative Example 4

A conductive paste was prepared in the manner of Working Example 4 except that ethyl cellulose having a weight average molecular weight of 230,000 was used as a binder of the conductive paste and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and

shearing velocity of 50 sec^{-1} .

[0254]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was $20.3 \text{ Ps}\cdot\text{s}$ and that the viscosity of the conductive paste measured under condition of
5 the shearing velocity of 50 sec^{-1} was $11.3 \text{ Ps}\cdot\text{s}$.

[0255]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a
10 screen printing machine, thereby forming an electrode layer having a thickness of $1 \text{ }\mu\text{m}$. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0256]

15 The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was $0.221 \text{ }\mu\text{m}$ and that since the surface roughness of
20 the electrode layer was too high, the electrode layer having a high surface smoothness could not be formed.

[0257]

It was reasonable to conclude that this was because the viscosity of the conductive paste at the shearing velocity of 50 sec^{-1} was too high to
25 print the conductive paste in a desired manner.

[0258]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated

multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 38 % and it was found that the short-circuit failure was very high.

[0259]

Comparative Example 5

A conductive paste was prepared in the manner of Working Example 4 except that ethyl cellulose having a weight average molecular weight of 130,000 was used as a binder of the conductive paste and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0260]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 5.3 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 3.2 Ps·s.

[0261]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0262]

The surface roughness (Ra) of the thus formed electrode layer was

measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.066 μm and that the surface smoothness of the electrode layer was high. However, it was found that since the viscosity of the conductive paste at the shearing velocity of 50 sec^{-1} was too low and the fluidity of the conductive paste was too high, the conductive paste leaked from a screen printing plate and the electrode layer could not be formed in a desired pattern.

[0263]

Comparative Example 6

A dielectric paste for forming a ceramic green sheet was prepared in the manner of Working Example 1 except that a copolymer of methyl methacrylate and butyl acrylate whose weight-average molecular weight was 230,000, copolymerization ratio (weight ratio) was 82:18 and Tg was 70 °C was used as a binder of a dielectric paste for forming a ceramic green sheet, thereby forming a ceramic green sheet.

[0264]

Further, a conductive paste was prepared in the manner of Working Example 5 and the viscosity of the thus prepared dielectric paste for forming a ceramic green sheet was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0265]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was 12.3 $\text{Ps}\cdot\text{s}$ and that the viscosity of the conductive paste measured under condition of

the shearing velocity of 50 sec^{-1} was $7.3 \text{ Ps}\cdot\text{s}$.

[0266]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of $1 \text{ }\mu\text{m}$. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0267]

The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was $0.120 \text{ }\mu\text{m}$ and that the electrode layer having a high surface smoothness was formed.

[0268]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 34 % and it was found that the short-circuit failure was so high that the samples were of no practical use.

[0269]

It is reasonable to conclude that this was because the weight-average molecular weight of the binder of the dielectric paste for forming a ceramic green sheet was 230,000, which was too low, so that

part of the ceramic green sheet was swollen and dissolved by the solvent.

[0270]

Comparative Example 7

A conductive paste was prepared in the manner of Working
5 Example 7 except that ethyl cellulose having a weight average molecular
weight of 230,000 was used as a binder of the conductive paste and the
viscosity of the thus prepared conductive paste was measured under
conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and
was also measured under conditions of a temperature of 25 °C and
10 shearing velocity of 50 sec⁻¹.

[0271]

As a result, it was found that the viscosity of the conductive paste
measured under condition of the shearing velocity of 8 sec⁻¹ was 21.1 Ps·s
and that the viscosity of the conductive paste measured under condition of
15 the shearing velocity of 50 sec⁻¹ was 11.9 Ps·s.

[0272]

Then, the thus prepared conductive paste was printed on a ceramic
green sheet fabricated in the manner of Working Example 1 using a
screen printing machine, thereby forming an electrode layer having a
20 thickness of 1 µm. Thus, a multi-layered unit including the ceramic green
sheet and the electrode layer laminated on the polyethylene terephthalate
film was fabricated.

[0273]

The surface roughness (Ra) of the thus formed electrode layer was
25 measured using the "SURFCORDER (SE-30D)" (Product Name)
manufactured by Kosaka Laboratory Ltd. in the manner of Working
Example 1. As a result, it was found that the surface roughness (Ra) of
the electrode layer was 0.241 µm and that since the surface roughness of

the electrode layer was too high, the electrode layer having a high surface smoothness could not be formed.

[0274]

It was reasonable to conclude that this was because the viscosity of the conductive paste at the shearing velocity of 50 sec^{-1} was too high to print the conductive paste in a desired manner.

[0275]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 40 % and it was found that the short-circuit failure was very high.

[0276]

Comparative Example 8

A conductive paste was prepared in the manner of Working Example 7 except that ethyl cellulose having a weight average molecular weight of 130,000 was used as a binder of a conductive paste and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25°C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25°C and shearing velocity of 50 sec^{-1} .

[0277]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was $5.5 \text{ Ps}\cdot\text{s}$ and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec^{-1} was $3.1 \text{ Ps}\cdot\text{s}$.

[0278]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm . Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0279]

The surface roughness (R_a) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was 0.069 μm and that the surface smoothness of the electrode layer was high. However, it was found that since the viscosity of the conductive paste at the shearing velocity of 50 sec^{-1} was too low and the fluidity of the conductive paste was too high, the conductive paste leaked from a screen printing plate and the electrode layer could not be printed in a desired manner.

[0280]

20 Comparative Example 9

A dielectric paste for forming a ceramic green sheet was prepared in the manner of Working Example 1 except that a copolymer of methyl methacrylate and butyl acrylate whose weight-average molecular weight was 230,000, copolymerization ratio (weight ratio) was 82:18, and T_g was 70 $^{\circ}\text{C}$ was used as a binder of a dielectric paste for forming a ceramic green sheet, thereby forming a ceramic green sheet.

[0281]

Further, a conductive paste was prepared in the manner of

Working Example 8 and the viscosity of the thus prepared dielectric paste for forming a ceramic green sheet was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing
5 velocity of 50 sec⁻¹.

[0282]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 13.3 Ps·s and that the viscosity of the conductive paste measured under condition of
10 the shearing velocity of 50 sec⁻¹ was 7.7 Ps·s.

[0283]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a
15 thickness of 1 μm. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0284]

The surface roughness (Ra) of the thus formed electrode layer was
20 measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.145 μm and that the electrode layer having a high surface smoothness was formed.

25 [0285]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a

multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 42 % and it was found that the short-circuit failure was so high that the samples were of no practical use.

[0286]

It is reasonable to conclude that this was because the weight-average molecular weight of the binder of the dielectric paste for forming a ceramic green sheet was 230,000, which was too low, so that part of the ceramic green sheet was swollen and dissolved by the solvent.

[0287]

Comparative Example 10

A conductive paste was prepared in the manner of Working Example 10 except that ethyl cellulose having a weight average molecular weight of 230,000 was used as a binder of the conductive paste and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

[0288]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 20.5 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 11.8 Ps·s.

[0289]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a

thickness of 1 μm . Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0290]

5 The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.221 μm and that since the surface roughness of
10 the electrode layer was too high, the electrode layer having a high surface smoothness could not be formed.

[0291]

It was reasonable to conclude that this was because the viscosity of the conductive paste at the shearing velocity of 50 sec^{-1} was too high to
15 print the conductive paste in a desired manner.

[0292]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a
20 multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 39 % and it was found that the short-circuit failure was very high.

[0293]

25 Comparative Example 11

A conductive paste was prepared in the manner of Working Example 10 except that ethyl cellulose having a weight average molecular weight of 130,000 was used as a binder of the conductive paste and the

viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

5 [0294]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 5.2 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 3.0 Ps·s.

10 [0295]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
15 sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0296]

The surface roughness (Ra) of the thus formed electrode layer was measured using the "SURFCORDER (SE-30D)" (Product Name)
20 manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.063 μm and that the surface smoothness of the electrode layer was high. However, it was found that since the viscosity of the conductive paste at the shearing velocity of 50 sec⁻¹ was too low and
25 the fluidity of the conductive paste was too high, the conductive paste leaked from a screen printing plate and the electrode layer could not be formed in a desired pattern.

[0297]

Comparative Example 12

A dielectric paste for forming a ceramic green sheet was prepared in the manner of Working Example 1 except that a copolymer of methyl methacrylate and butyl acrylate whose weight-average molecular weight
5 was 230,000, copolymerization ratio (weight ratio) was 82:18, and T_g was 70 °C was used as a binder of a dielectric paste for forming a ceramic green sheet, thereby forming a ceramic green sheet.

[0298]

Further, a conductive paste was prepared in the manner of
10 Working Example 11 and the viscosity of the thus prepared dielectric paste for forming a ceramic green sheet was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

15 [0299]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 11.7 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 6.6 Ps·s.

20 [0300]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
25 sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0301]

The surface roughness (Ra) of the thus formed electrode layer was

measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.189 μm .

5 [0302]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not
10 short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 56 % and it was found that the short-circuit failure was so high that the samples were of no practical use.

[0303]

15 It is reasonable to conclude that this was because the weight-average molecular weight of the binder of the dielectric paste for forming a ceramic green sheet was 230,000, which was too low, so that part of the ceramic green sheet was swollen and dissolved by the solvent.

[0304]

20 Comparative Example 13

A conductive paste was prepared in the manner of Comparative Example 2 except that a mixed solvent of terpineol and kerosene (mixture ratio (mass ratio) of 50:50) was used instead of isobornyl acetate as the solvent for preparing the conductive paste and the viscosity of the thus
25 prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec^{-1} and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec^{-1} .

[0305]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec^{-1} was $10.7 \text{ Ps}\cdot\text{s}$ and that the viscosity of the conductive paste measured under condition of
5 the shearing velocity of 50 sec^{-1} was $6.7 \text{ Ps}\cdot\text{s}$.

[0306]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a
10 thickness of $1 \text{ }\mu\text{m}$. Thus, a multi-layered unit including the ceramic green sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0307]

The surface roughness (R_a) of the thus formed electrode layer was
15 measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (R_a) of the electrode layer was $0.130 \text{ }\mu\text{m}$ and that the electrode layer having a high surface smoothness was formed.

20 [0308]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not
25 short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 46 % and it was found that the short-circuit failure was so high that the samples were of no practical use.

[0309]

It is reasonable to conclude that this was because the mixed solvent of terpeneol and kerosene used as a solvent of the conductive paste dissolved a copolymer of methyl methacrylate and butyl acrylate used as
5 the binder of the ceramic green sheet.

[0310]

Comparative Example 14

A conductive paste was prepared in the manner of Comparative Example 2 except that terpeneol was used instead of isobornyl acetate as
10 the solvent for preparing the conductive paste and the viscosity of the thus prepared conductive paste was measured under conditions of a temperature of 25 °C and shearing velocity of 8 sec⁻¹ and was also measured under conditions of a temperature of 25 °C and shearing velocity of 50 sec⁻¹.

15 [0311]

As a result, it was found that the viscosity of the conductive paste measured under condition of the shearing velocity of 8 sec⁻¹ was 13.1 Ps·s and that the viscosity of the conductive paste measured under condition of the shearing velocity of 50 sec⁻¹ was 6.9 Ps·s.

20 [0312]

Then, the thus prepared conductive paste was printed on a ceramic green sheet fabricated in the manner of Working Example 1 using a screen printing machine, thereby forming an electrode layer having a thickness of 1 μm. Thus, a multi-layered unit including the ceramic green
25 sheet and the electrode layer laminated on the polyethylene terephthalate film was fabricated.

[0313]

The surface roughness (Ra) of the thus formed electrode layer was

measured using the "SURFCORDER (SE-30D)" (Product Name) manufactured by Kosaka Laboratory Ltd. in the manner of Working Example 1. As a result, it was found that the surface roughness (Ra) of the electrode layer was 0.192 μm and that since the surface roughness of the electrode layer was too high, the electrode layer having a high surface smoothness could not be formed.

[0314]

It is reasonable to conclude that this was because terpeneol used as a solvent of the conductive paste dissolved a copolymer of methyl methacrylate and butyl acrylate used as the binder of the ceramic green sheet.

[0315]

Further, a total of fifty multi-layered ceramic capacitor samples were fabricated and the resistance value of each of the thus fabricated multi-layered ceramic capacitor samples was measured using a multi-meter in a manner of Working Example 1 to check whether or not short-circuit failure occurred therein. As a result, the short-circuit failure ratio of the multi-layered ceramic capacitor samples was found to be 76 % and it was found that the short-circuit failure was so high that the samples were of no practical use.

[0316]

It is reasonable to conclude that this was because terpeneol used as a solvent of the conductive paste dissolved a copolymer of methyl methacrylate and butyl acrylate used as the binder of the ceramic green sheet.

[0317]

It was found from Working Examples 1 to 18 and Comparative Examples 13 and 14 that in the case where the conductive paste

containing ethyl cellulose having a weight average molecular weight of 130,000 as a binder and the mixed solvent of terpeneol and kerosene (mixture ratio (mass ratio) of 50:50) as a solvent or the conductive paste containing ethyl cellulose having a weight average molecular weight of 130,000 as a binder and terpeneol as a solvent was printed on the ceramic green sheet formed by using the dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a binder, thereby fabricating the multi-layered unit, and fifty of the multi-layered units were laminated, thereby fabricating the multi-layered ceramic capacitor, the solvent of the conductive paste dissolved a copolymer of methyl methacrylate and butyl acrylate contained in the ceramic green sheet as a binder, so that the ceramic green sheet was swollen or partially dissolved, thereby generating pinholes or cracks in the ceramic green sheet and causing the short-circuit failure ratio of the multi-layered ceramic capacitors to become extremely high, while in the case where the conductive paste containing ethyl cellulose having an apparent weight average molecular weight of 155,000 to 205,000 defined by $X \cdot MW_L + (1-X) \cdot MW_H$ as a binder and isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, l-menthyl acetate, l-citronellol, l-perillyl alcohol or acetoxymethoxyethoxycyclohexanol acetate as a solvent was printed on the ceramic green sheet formed by using the dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a binder, thereby

fabricating the multi-layered unit, and fifty of the multi-layered units were laminated, thereby fabricating the multi-layered ceramic capacitor, the solvent of the conductive paste hardly dissolved a copolymer of methyl methacrylate and butyl acrylate contained in the ceramic green sheet as a
5 binder, so that the ceramic green sheet was not swollen or partially dissolved, thereby preventing generation of pinholes or cracks in the ceramic green sheet and markedly decreasing the short-circuit failure ratio of the multi-layered ceramic capacitors.

[0318]

10 Further, it was found from Working Examples 1 to 18 and Comparative Examples 1, 4, 7 and 10 that in the case where the conductive paste containing ethyl cellulose having a weight average molecular weight of 230,000 as a binder and isobornyl acetate as a solvent, the conductive paste containing ethyl cellulose having a weight average
15 molecular weight of 230,000 as a binder and dihydroterpinyl methyl ether as a solvent, the conductive paste containing ethyl cellulose having a weight average molecular weight of 230,000 as a binder and dihydroterpinyl oxyethanol as a solvent or the conductive paste containing ethyl cellulose having a weight average molecular weight of
20 230,000 as a binder and terpinyl methyl ether as a solvent was printed on the ceramic green sheet formed by using the dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a
25 binder, thereby fabricating the multi-layered unit, and fifty of the multi-layered units were laminated, thereby fabricating the multi-layered ceramic capacitor, the viscosity of the conductive paste was so high that it was impossible to print the conductive paste on the ceramic green sheet in

a desired manner to form an electric layer having a high surface smoothness, so that the short-circuit failure ratio of the multi-layered ceramic capacitors became extremely high, while in the case where the conductive paste containing ethyl cellulose having an apparent weight average molecular weight of 155,000 to 205,000 defined by $X \cdot MW_L + (1-X) \cdot MW_H$ as a binder and isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, l-menthyl acetate, l-citronellol, l-perillyl alcohol or acetoxymethoxyethoxycyclohexanol acetate as a solvent was printed on the ceramic green sheet formed by using the dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a binder, thereby fabricating the multi-layered unit, and fifty of the multi-layered units were laminated, thereby fabricating the multi-layered ceramic capacitor, the conductive paste had a viscosity suitable for printing, so that it was possible to form an electric layer on a ceramic green sheet in a predetermined pattern using a screen printing machine in a desired manner and fabricate multi-layered ceramic capacitors whose short-circuit failure ratio was low.

[0319]

Furthermore, it was found from Working Examples 1 to 18 and Comparative Examples 2, 5, 8 and 11 that in the case where the conductive paste containing ethyl cellulose having a weight average molecular weight of 130,000 as a binder and isobornyl acetate as a solvent, the conductive paste containing ethyl cellulose having a weight average molecular weight of 130,000 as a binder and dihydroterpinyl methyl ether as a solvent, the conductive paste containing ethyl cellulose having a

weight average molecular weight of 130,000 as a binder and dihydroterpinyl oxyethanol as a solvent or the conductive paste containing ethyl cellulose having a weight average molecular weight of 130,000 as a binder and terpinyl methyl ether as a solvent was printed on the ceramic green sheet formed by using the dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a binder, thereby fabricating the multi-layered unit, the viscosity of the conductive paste was too low and the fluidity of the conductive paste was too high, so that the conductive paste leaked from a screen printing plate and the electrode layer could not be formed in a desired pattern, while in the case where the conductive paste containing ethyl cellulose having an apparent weight average molecular weight of 155,000 to 205,000 defined by $X \cdot MW_L + (1-X) \cdot MW_H$ as a binder and isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol or acetoxy-methoxyethoxy-cyclohexanol acetate as a solvent was printed on the ceramic green sheet formed by using the dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a binder, thereby fabricating the multi-layered unit, and fifty of the multi-layered units were laminated, thereby fabricating the multi-layered ceramic capacitor, the conductive paste had a viscosity suitable for printing, so that it was possible to form an electric layer on a ceramic green sheet in a predetermined pattern using a screen printing machine in a desired

manner and fabricate multi-layered ceramic capacitors whose short-circuit failure ratio was low.

[0320]

Moreover, it was found from Working Examples 1 to 18 and
5 Comparative Examples 3, 6 and 9 that in the case where the conductive
paste containing ethyl cellulose having an apparent weight average
molecular weight of 180,000 as a binder and isobornyl acetate as a solvent,
the conductive paste containing ethyl cellulose having an apparent
weight average molecular weight of 180,000 as a binder and
10 dihydroterpinyl methyl ether as a solvent, the conductive paste
containing ethyl cellulose having an apparent weight average molecular
weight of 180,000 as a binder and dihydroterpinyl oxyethanol as a solvent
or the conductive paste containing ethyl cellulose having an apparent
weight average molecular weight of 180,000 as a binder and terpinyl
15 methyl ether as a solvent was printed on the ceramic green sheet formed
by using the dielectric paste containing a copolymer of methyl
methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram,
copolymerization ratio (weight ratio) was 82:18, weight-average
molecular weight was 450,000 and T_g was 70 °C as a binder, thereby
20 fabricating the multi-layered unit, the short-circuit failure ratio of the
multi-layered ceramic capacitors became very high, while in the case
where the conductive paste containing ethyl cellulose having an apparent
weight average molecular weight of 155,000 to 205,000 defined by $X \cdot MW_L + (1-X) \cdot MW_H$ as a binder and isobornyl acetate, dihydroterpinyl
25 methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl
oxyethanol, d-dihydrocarveol, l-menthyl acetate, l-citronellol,
l-perillyl alcohol or acetoxy-methoxyethoxy-cyclohexanol acetate as a
solvent was printed on the ceramic green sheet formed by using the

dielectric paste containing a copolymer of methyl methacrylate and butyl acrylate whose acid value was 5 mgKOH/gram, copolymerization ratio (weight ratio) was 82:18, weight-average molecular weight was 450,000 and Tg was 70 °C as a binder, thereby fabricating the multi-layered unit, and fifty of the multi-layered units were laminated, thereby fabricating the multi-layered ceramic capacitor, the short-circuit failure ratio of the multi-layered ceramic capacitors markedly decreased. It is reasonable to assume that this was because the weight-average molecular weight of the binder of the dielectric paste for forming a ceramic green sheet was 230,000, which is too low, so that part of the ceramic green sheet was swollen and dissolved by the solvent.

[0321]

Further, it was found that in the case where a dielectric paste adapted for forming a spacer layer and containing ethyl cellulose having an apparent weight average molecular weight of 110,000 to 180,000 defined by $X \cdot MW_L + (1-X) \cdot MW_H$ as a binder and isobornyl acetate, dihydroterpinyl methyl ether, dihydroterpinyl oxyethanol, terpinyl methyl ether, terpinyl oxyethanol, d-dihydrocarveol, I-menthyl acetate, I-citronellol, I-perillyl alcohol or acetoxy-methoxyethoxy-cyclohexanol acetate as a solvent was prepared and the dielectric paste was printed on the ceramic green sheet in a complimentary pattern to that of the electrode layer, thereby forming a spacer layer, the same results as those above were obtained.

[0322]

The present invention has thus been shown and described with reference to the preferred embodiments and the working examples. However, it should be noted that the present invention is in no way limited to the details of the described arrangement but changes and

modifications may be made without departing from the scope of the appended claims.

[0323]

According to the present invention, it is possible to provide a
5 conductive paste for a multi-layered ceramic electronic component which
does not dissolve a binder contained in a layer adjacent to an electrode
layer of the multi-layered ceramic electronic component, can reliably
prevent short circuit failure from occurring in a multi-layered ceramic
electronic component and has excellent printability.

10 [0324]

Further, according to the present invention, it is possible to
provide a method for manufacturing a multi-layered unit for a
multi-layered ceramic electronic component which can reliably prevent
short circuit failure from occurring in a multi-layered ceramic electronic
15 component and form an electrode layer in a desired manner.